

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013186**Date Inspected:** 25-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

7BE

Shield Metal Arc Welding (SMAW) welding was performed on X37 deck plate member located between panel point 49 and 50 cross beam side of segment. Welder is identified as Mr. Guo Taotao (050969). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-4113-1.

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7AE

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Miscellaneous Work In Progress

ZPMC Ship

QA Inspector observed ZPMC's personnel performing various job functions on ZPMC Ship. Locations and description of work are as followed:

6 West, 6 East, 5 West, 5 East, CB 4~6

1. Various activity such as; bolt installation, scaffolding removal, suspender bracket and coating touch up, being performed throughout segments and cb members.

NDT Observation

This QA Inspector observed ZPMC Ultra Sonic Testing (UT) Technician performed UT on various locations in the trial assembly yard. Locations are as followed:

7BE+7CE

1. Performed on the side plate weld splice OBE7B-009 and 010 bike path side of segment.

2. Performed on the bottom plate weld splice OBE7B-008 of segment.

NDT Observation

This QA Inspector observed ZPMC Magnetic Particle Testing (MT) Technician performed MT on various locations in the trial assembly yard. Locations are as followed:

7CE+7BE

1. Performed at excavations on deck plate weld splice OBE7-007 cross beam side of segment at Y location 230mm.

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2. Performed at excavations on deck plate weld splice OBE7-008 cross beam side of segment at Y locations 13000, 10800, 10300, and 2000mm.
3. Performed at excavations on edge plate weld splice OBE7-006 cross beam side of segment at Y locations 1000 and 500mm.
4. Performed at excavations on edge plate weld splice OBE7-010 cross beam side of segment at Y locations 11000, 850, 650, 360 and 100mm.

NOTE:

Due to ZPMC work personnel being utilized on the ZPMC ship for the shipment of OBG 5 and 6 (east/west) segments, work was limited in the trail assembly yard on today's work shift.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz, Joe	Quality Assurance Inspector
Reviewed By:	Miller, Mark	QA Reviewer
